

Split

Work Order ID 165774 - 2

165774

Page 1

Monday, August 28, 2017 2:20:07 PM

Item ID: D5283-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Clamp Assembly

Start Date: 8/30/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/12/2017 Req'd Qty: 10.00

10

Customer:

Reference: DAS 13

Approvals: Process Plan:

Date: AUG 28 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5283

A

100

0.00

100

Bandsaw

Memo

0.39

Jeaspa Bandsaw

CUT TO 5.5" LONG

FM
17/08/29

105

0.00

105

Purchasing

Memo

0.00

Purchasing

Issue p.o. 37611
Possible supplier: Metec
Machine, Alodine and powder Coat as per Dwg***Note mask bore prior to powder coat***

C of C is required

10
AUB
AUG 30 2017

Work Order ID 165774

Monday, August 28, 2017 2:20:07 PM

165774

Page 2

Item ID: D5283-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Basket Clamp Assembly

Stop

NS2

Start Date: 8/30/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/12/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

10 X SP 17-9-15

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

10 X

SEP 18 2017

DAS

9

9-89

190

0.00

190

Small Fab

Memo

2.77

Small Fab

PRESS FIT BEARING AND STAKE 4 PLACES PER SIDE AS PER DWG

9X

17/09/27

DAS

36

9-89

121

Chemical conversion (10) 2017-09-19 JSC

122

QC 7

10 X 1709-20

10 X 1709-20

M 138014

START: 11.05

O.T. 320°

10 X 1709-20

10 X 1709-20

DAS

10

9-89

123

Powder coat White as per drawing

Mask bearing bore

FINISH: 11.35

124

QC 3

Work Order ID 165774

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Page 3

Item ID: D5283-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Clamp Assembly

Start Date: 8/30/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/12/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location: St 503

0.00

210

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

9

DAS
38
9-89

9

SEP 25 2017

DAS
6
9-89DAS
21
9-89

SEP 27 2017

DAS
21
9-89

SEP 27 2017

Picklist Print

Monday, August 28, 2017 2:20:05 PM

Page 1

Work Order ID: 165774

165774

Parent Item: D5283-041

D5283-041

Parent Item Name: Basket Clamp Assembly

Start Date: 8/30/2017

Required Date: 9/12/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 15.07.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611		Manufactured	No			190	Each	9.0000	1	10			
D2611									**				
Bearing													
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					ST008A	9							
					150049	9							
D5283-1P		Purchased	No			105	Each	0.0000	1	10			
D5283-1P									**				
Basket Clamp													
M6061T6B30000X01.5		Purchased	No			100	f	8.0000	0.46	4.842105			
00													
M6061T6B30000X01.500									**				
6061-T6 Bar 3.00 x 1.50													
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					MAT004	8							
					m135559	8							

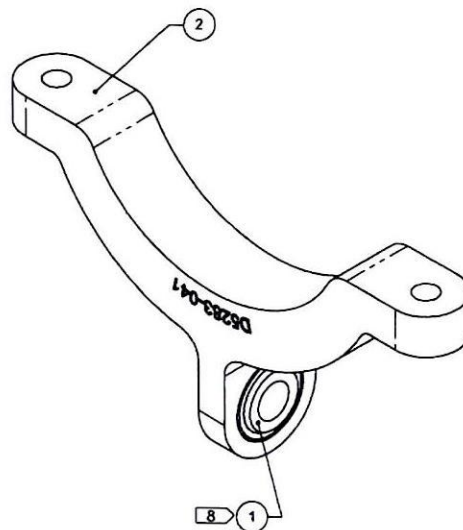
166445 (7x) 166254 (2x)

10x 8/17 9-15

A.8A FM 17/08/29

DAS
36
9-88

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-041	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-1	BASKET CLAMP



D5283-041 BASKET CLAMP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

DAS
13
9-80

AUG 28 2017

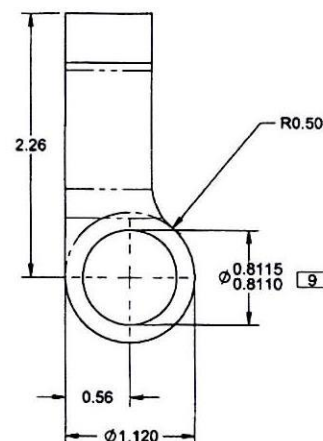
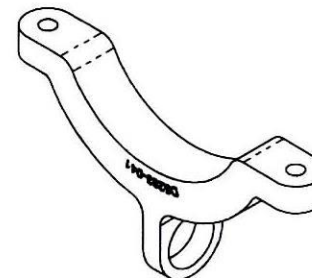
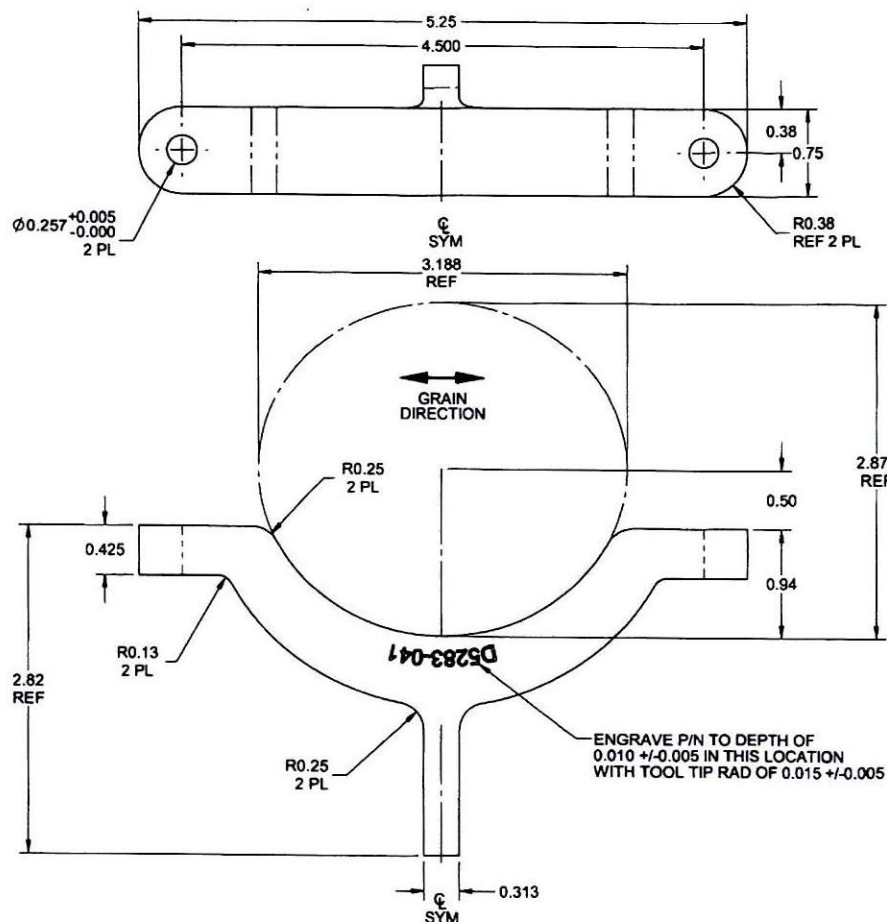
W/O: 165774

RELEASED
2015-07-20
ERN 15-607

A NEW ISSUE		DB	15.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 1 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
DATE	15.06.30	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1



D5283-1 BASKET CLAMP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M8061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-041 PER QSI 044 6.3
- 7) WEIGHT: 0.24 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-1.Rev A.STEP
- 9) MASK BEARING BORE PRIOR TO POWDER COAT

RELEASED
2015-07-20

APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5283	SHEET 3 OF 6
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	BASKET CLAMP ASSY	NTS
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8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO37611

Purchase Order Date 8/30/2017

PO Print Date 9/1/2017

Page Number 1 of 3

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Revised

Contact Name
Vendor Phone 613 678 3957

Ship To Contact
Ship To Phone
Ship Via: Dart Truck
Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D5283-1P	Basket Clamp	9/12/2017 Yes 9/12/2017	FN	10.00 Each	\$14.75	\$147.50
Machine as per Dwg D5283 Rev. A B165774 NO ALODINE AND POWDER COAT							
DAS 8-80							
SP 17-9-15							
Line Total:							\$147.50
2	D5283-3P	Basket Clamp	9/12/2017 Yes 9/12/2017	FN	10.00 Each	\$28.75	\$287.50
Machine as per Dwg D5283 Rev. A B165775 NO ALODINE AND POWDER COAT							
Line Total:							\$287.50

Note:

9/1/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21854
Date: Sep 14, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 37611	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Sep 14, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5283-1 Basket Clamp, no finishing no set up fee, will be done at the same time as PO 37426	Each	10	10	
D5283-3 Basket Clamp, no finishing Set-up fee for quantities below 25 pcs.	Each	10	10	
	Each	1	1	
D5283-11 Basket Clamp, no finishing no set up fee, will be done at the same time as PO 37426	Each	10	10	
D5283-7 Basket Clamp, no finishing no set up fee, will be done at the same time as PO 37426	Each	10	10	
SPR-9-15.				
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>Daryl</u>		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>		<u>P.O. NUMBER</u>
10	D5283-1P ✓	Basket Clamp	Material B165774	37611
10	D5283-3P	Basket Clamp	Material B165775	37611
10	D5283-11P	Basket Clamp	Material B165778	37611
10	D5283-7P	Basket Clamp	Material B165779	37611

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, September 14, 2017